

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012349**Date Inspected:** 01-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Segment-10AE

During random Quality Assurance Visual review of welds located on segment 9DW, this Quality Assurance Inspector (QA) discovered the following issues:

-Two (2) linear indications measuring approximately 8 mm in length.

-The indications are clearly marked on the material near the weld.

-The welds are identified as:

1. FB012-028-001, Transverse crack, approximately 8 mm in length@ PP88, Y location-2160 mm from Bike Path side.

2. FB012-028-001, Transverse crack, approximately 8 mm in length@ PP88, Y location-2575 mm from Bike Path side.

-These welds are Fillet weld joining the Floor beam Web to Flange.

- The Floor beam Web to Flange is identified as non SPCM.

- These welds are designated as non Seismic Performance Critical Member (non SPCM).

-OBG segment 10AE is located front side of OBG Bay#13.

- The indications were discovered visually and confirmed by Magnetic particle Testing (MT) by Caltrans QA.

-ZPMC Quality Control Personnel have performed 25% Magnetic Particle Testing of these welds.

For further information, see the attached pictures below. Please see incident report on this date.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Segment 10AE

This QA inspector performed VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Components. The weld designations reviewed are as follows. For further information, please see attached pictures.

-(FB003-168-004/005)@ PP88

-(FB012-028-001/002)@ PP88

-(FB028-009-092/93)@ PP88

Segment 10CE

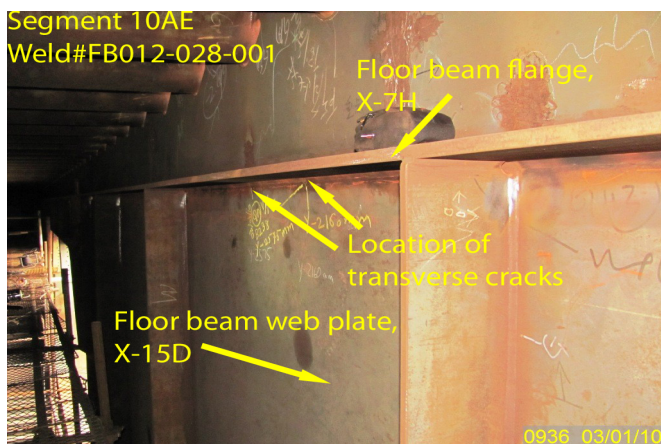
This QA inspector performed VT of approximately 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Components. The weld designations reviewed are as follows. For further information, please see attached pictures.

-(FB003-162-004/005)@ PP92

-(FB012C-001/002)@ PP92

-(FB020-005-092/93)@ PP92

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
